

We claim:-

1. A method of producing hollow moldings in a tool carrier,
5 comprising the steps of
 - (i) filling the starting components for producing the
moldings into a mold (iv), which has a core (v) which
defines the hollow space of the molding,
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 - (ii) opening the mold (iv), the molding being securely held
by the core (v),
 - (iii) removing the molding from the core (v),
15the molding being removed from the core (v) outside the mold
(iv), wherein the starting components for producing the
moldings are filled into a mold (iv) which is provided with
release agent and which has a core (v) which is attached to
20 the base or to the cover, defines the hollow space of the
molding and is connected to at least one further core (vi),
which is located outside the mold (iv), the mold (iv) is
closed, after opening of the mold (iv) the core (v) is moved
upward or downward out of the mold (iv) defined by the outer
25 walls, the core (v) is exchanged for the core (vi), which is
not holding a molding, by a pivoting movement through 180°,
the core (vi) is moved into the mold (iv), with the core (v)
arriving in a position from which the moldings are stripped
off the core (v), connected to the core (vi), when the core
30 (vi) is removed from the mold (iv).
2. A method as claimed in claim 1, wherein the moldings are
produced in a fixed-cycle line comprising at least 4 tool
carriers.
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3. A method as claimed in claim 1, wherein the tool carrier has
at least two cores (v) and (vi), which are alternately
introduced into the mold (iv).
- 40 4. A method as claimed in claim 1, wherein the moldings are
based on thermoplastic materials, rubber and/or plastics
produced from reactive starting components in the mold (iv).
5. A method as claimed in claim 1, wherein the starting
45 components for producing the moldings comprise a reaction
mixture containing (a) isocyanates and (b) compounds reactive

Drawing

to isocyanates, with which mixture cellular polyurethane elastomers are produced as moldings.

6. A method as claimed in claim 1, wherein the molding is
5 removed from the core (v) 1 min to 60 min after the opening of the mold (iv).
7. A method as claimed in claim 1, wherein the molding is
10 subjected to a setpoint/actual comparison outside the mold (iv) before removal from the core (v).
8. A method as claimed in claim 1, wherein the molding is
15 processed outside the mold (iv) before removal from the core (v).
9. A tool for producing hollow moldings including at least one
20 mold (iv) and at least two cores (v) and (vi), which determine the hollow space of the molded parts, wherein the cores (v) and (vi) can be alternately positioned in the mold (iv) and the cores (v) and (vi) are pivotably mounted, the common pivot axis lying parallel to the longitudinal axis of the cores and centrally between the cores (v) and (vi).
10. A tool as claimed in claim 9, wherein the cores (v) and (vi)
25 are arranged such that they are aligned in parallel and movable parallel to the longitudinal axis of the cores.
11. A tool as claimed in claim 9, wherein the tool has a device
30 with which the molding is stripped off the core (v).
12. A tool as claimed in claim 9, wherein the tool is arranged
35 movably in a fixed-cycle line, which is preferably circulating and operated continuously, with a mixing head fixed in place in relation to the tool for filling the starting components for producing the moldings into the mold (iv).
13. A fixed-cycle line for producing moldings, wherein the
40 fixed-cycle line has at least one tool as claimed in claim 9.
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